

Work Order ID 130350

130350

Page 1

Friday, March 06, 2015 11:30:19 AM

Item ID: D4018-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Short Basket Lid Assembly (350)

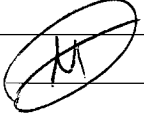
Start Date: 3/09/15 Start Qty: 1.00 *1*

Required Date: 3/18/15 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  Date: 5-3-6 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4018	D

100 Weld per dwg A/R S.S. rod Batch: 131417 0.00

100

Large Fab

Large Fab

1 MAR 13 2015 DAS 24 9-33

Memo 0.00

1- assemble ribs , weld as per dwg D4018 using DT9607B

2- weld hinge (3) and Mounting brackets as per dwg D4018

inspect before welding mesh

3- tack weld mesh on basket as per dwg D4018

make sure to place mesh correctly on lid, check with label plate before tacking mesh

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

1x 17 MAR 17 2015 DAS 43 9-33

Memo 0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130350

130350

Page 3

Friday, March 06, 2015 11:30:19 AM

Item ID: D4018-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Short Basket Lid Assembly (350)

Start Date: 3/09/15 Start Qty: 1.00 *1*

Required Date: 3/18/15 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
160	Identify as per dwg & Stock Location: <u>W/p</u>	0.00							
160									
Packaging	Memo	0.00							DAS 9 9-89
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

15.4-2

Friday, March 06, 2015 11:30:23 AM

130350

D4018-041

Required Date: 3/18/15

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP REV:E 13.08.21 DWG REV.D / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4018-1		Manufactured	No			100	Each	4.0000	2	2		MAR 13 2015	DAS 24 9-30
D4018-1									**				
Rib													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA004			4						
				120354			3						
				121816			1						
D4018-3		Manufactured	No			100	Each	0.0000	2	2		MAR 13 2015	DAS 24 9-30
D4018-3									**				
Rib													
D4016-3		Manufactured	No			100	Each	3.0000	3	3		MAR 13 2015	DAS 24 9-30
D4016-3									**				
Hinge Half, Lid													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA004			3						
				127644			3						
D4018-5		Manufactured	No			100	Each	15.0000	6	6		MAR 13 2015	DAS 24 9-30
D4018-5									**				
Rib													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA004			15						
				116885			15						

Picklist Print

Friday, March 06, 2015 11:30:23 AM

Page 2

Work Order ID: 130350

130350

Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 3/09/15

Required Date: 3/18/15

Start Qty: 1.00

Required Qty: 1.00

D4035-043	Manufactured	No	100	Each	6.0000	2	2	MAR 13 2015	DAS
D4035-043								24	9-30
Lid Rib Assembly, Aft (350 Basket)									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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WA004

6

127809

6

2

D2581	Manufactured	No	100	Each	93.0000	2	2	MAR 13 2015	DAS
D2581								24	9-30
Mounting Bracket									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004

93

102265

38

122730

10

127716

45

2

D4020-7	Manufactured	No	100	Each	2.0000	1	1	MAR 13 2015	DAS
D4020-7								24	9-30
Mesh (350 Basket Short, Lid)									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA004

2

129814

2

1

D4021-3	Manufactured	No	100	Each	4.0000	1	1	MAR 13 2015	DAS
D4021-3								24	9-30
Data Plate									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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WA004

4

125833

4

1

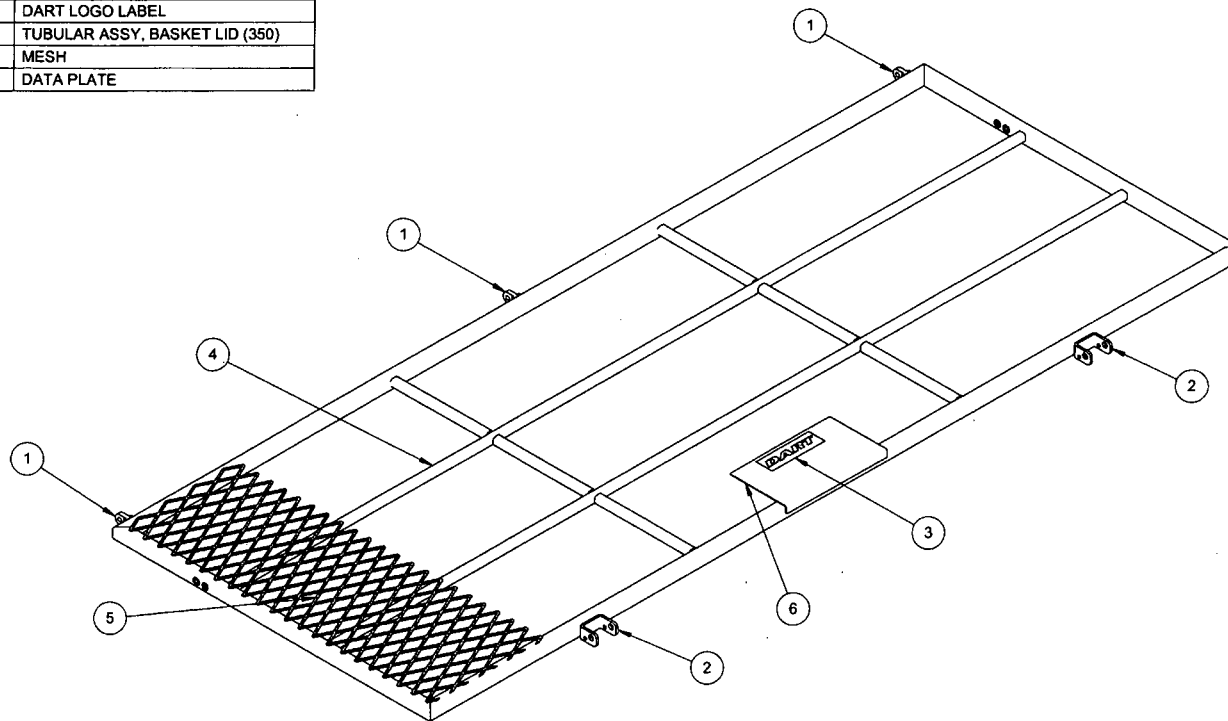
D2728-3	Manufactured	Yes	140	Each	0.0000	0	0		
D2728-3									
Dart Logo Label Large									

Friday, March 06, 2015 11:30:23 AM

Shop Packet Print

Page 2

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE

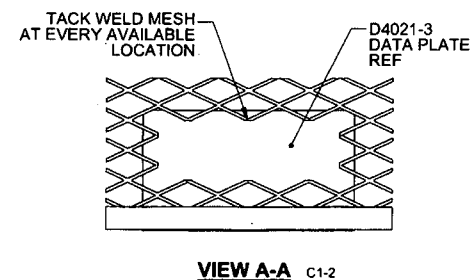
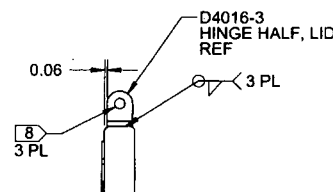
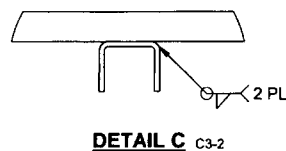
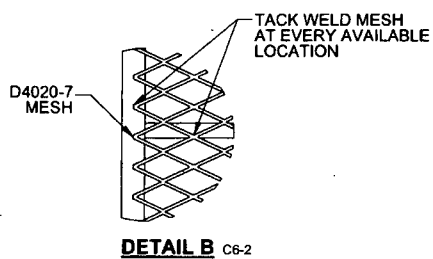
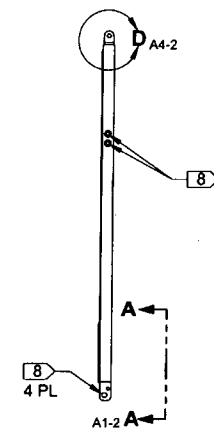
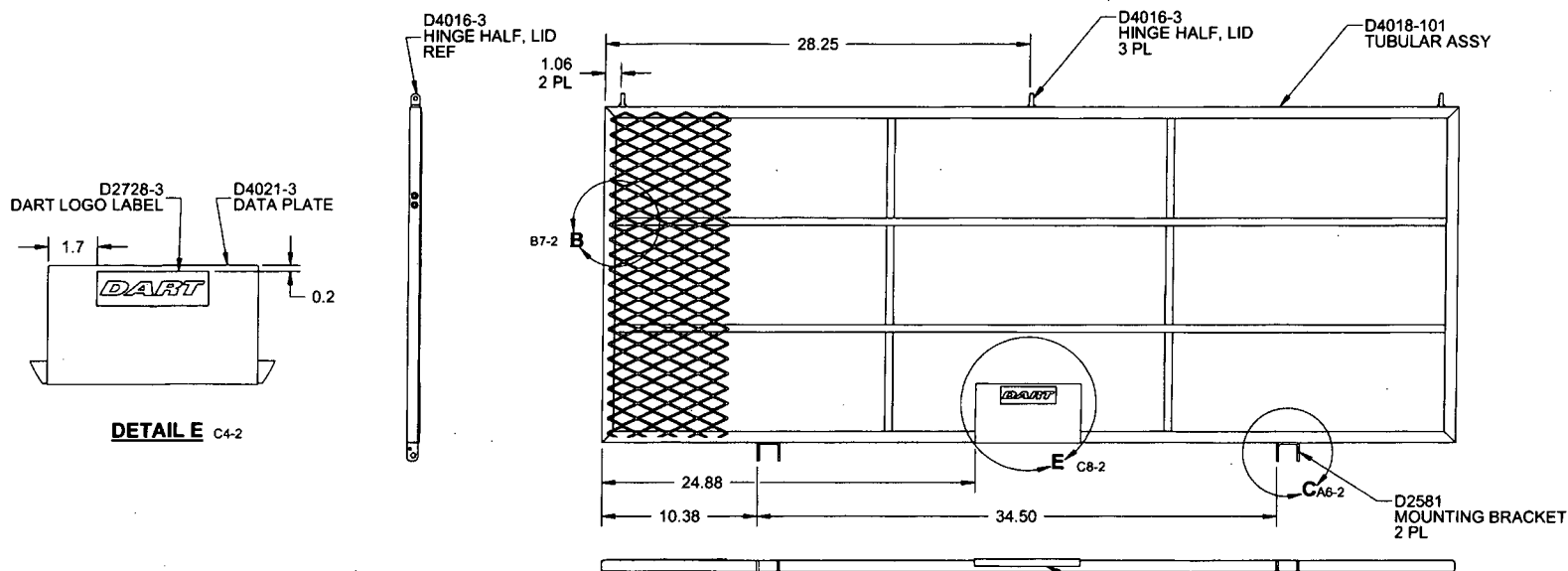


D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

Handwritten signature and date:
15-3-6

RELEASED
2013-08-16

D	C7-3 D4035-043 WAS D4035-041 (REASON: PROPARM OPTION DELETED).	AJS	13.07.18
C	REMOVED D4086-232. UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4018	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET LID ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DOWNLOADED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

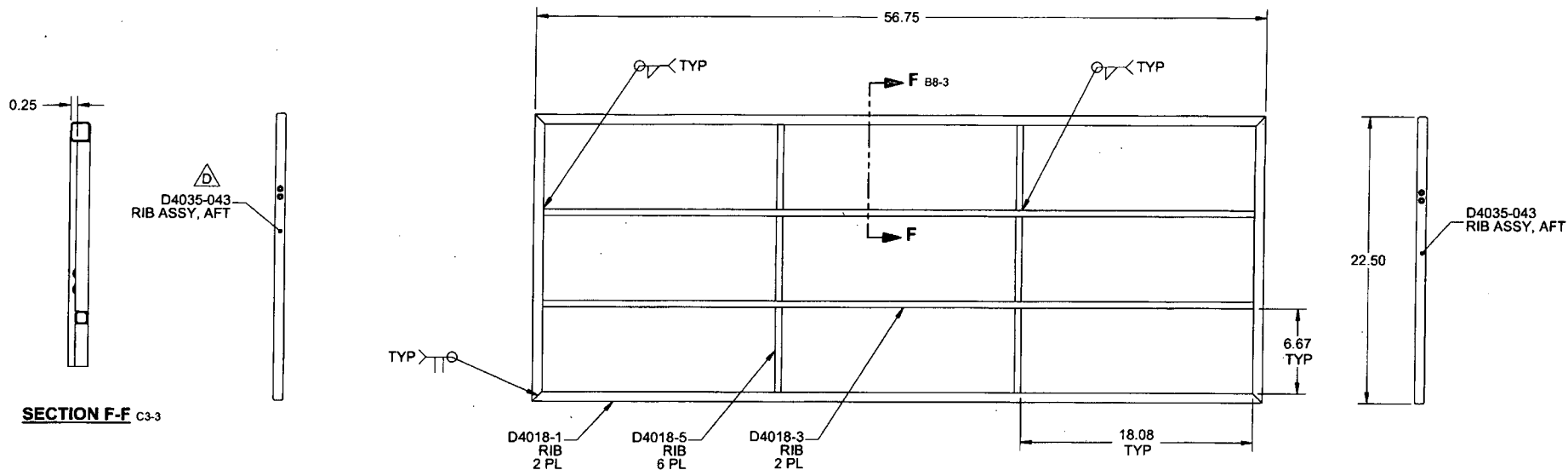
D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DETAIL D D1-2

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4018	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
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RELEASED
2013-08-16

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



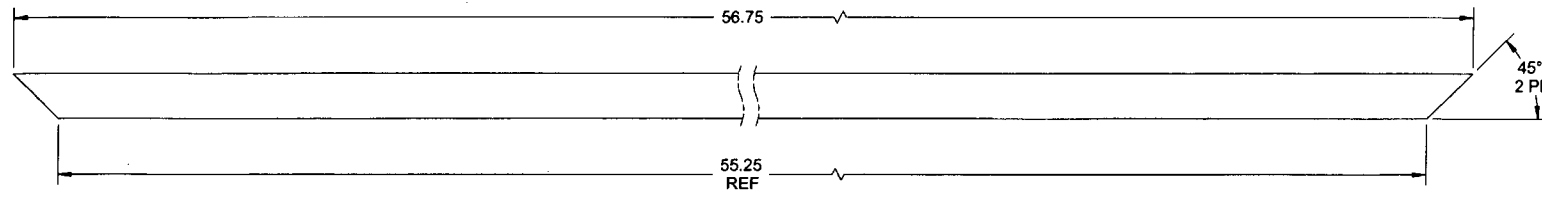
8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
2013-08-16

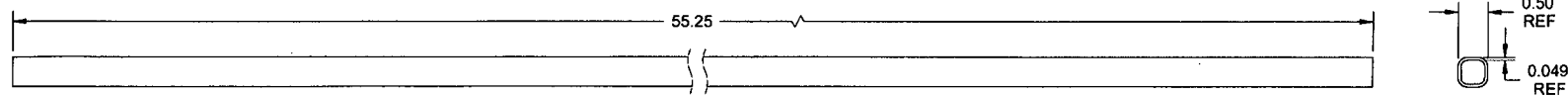
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

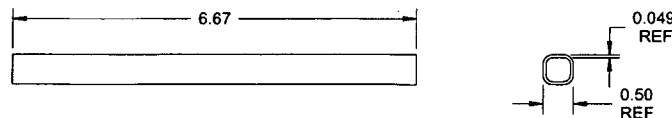
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4018	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
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D4018-1 RIB



D4018-3 RIB



D4018-5 RIB

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2013-08-16
NH

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Y	DRAWING NO. D4018	REV. D
MFG. APPR.	W	SHEET 4 OF 4	
APPROVED	W	TITLE	SCALE
DE APPR.	W	SHORT BASKET LID ASSY (350) NTS	
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